

Date: Wednesday, 4/4/2007 9:03:42 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING
Job Number : 31610	
Estimate Number : 10310	
P.O. Number : <i>N/A</i>	Part Number : D26175
This Issue : 4/4/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2617 REV D2
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : D2
Previous Run : 31033	Material : <i>N/A</i>
Written By : _____	Due Date : 4/15/2007 Qty: 30 Um: Each
Checked & Approved By : <i>07.04.04</i>	
Comment : Est H 04.07.14 Reformat; added step 5 KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W
-----	------------------	--------------------------



Comment: Qty.: 0.0205 f(s)/Unit Total : 0.6143 f(s)  
6061-T6 Round Bar 1.5"  
Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)  
Ø0.500" tubing x 0.058" wall  
M6061T6T0.500W.058)  
Batch *1104 007*

*SF 07/04/17*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL  
  
1-Machine as per Folio FA438 and Dwg D2617  
  
2-Deburr

*SF 07/04/17* (35)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SF 07/04/17*

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*SF 07.04.17*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

*FL*

*07/04/23*

(35)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:03:42 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 31610

Part Number: D26175

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

*EP 04/04/23*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*EP 04/04/23 (35)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*(35)*

Comment: FINAL INSPECTION/W/O RELEASE

*04/04/24*

Job Completion



*u 04.04.24*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



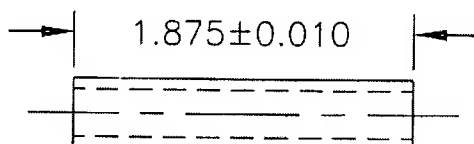


DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE	01.07.04			TITLE BUSHING	SCALE 1:1

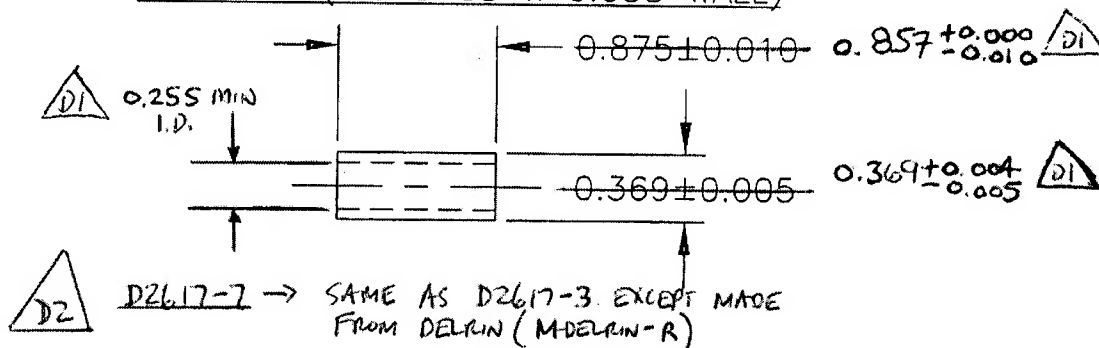
DZ 04.09.10 #CP ADD D2617-7

A	96.10.08	NEW ISSUE
B	97.05.08	.875 WAS 1.125
C	97.06.04	0.369 DIA WAS 0.375
D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE
D1	CP # 04.07.12	CORRECT TOLERANCE (NCR 779)

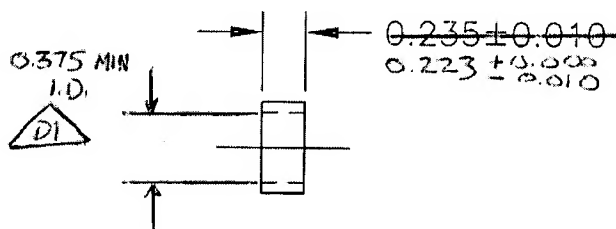
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED  
01.07.05 #

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31610

#### NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)  
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.